

AIRLESS SPRAY APPLICATION - Thin AC-816 to 16 seconds viscosity in a #5 Zahn cup with perchloroethylene.

Equipment:

1. Cold or hot circulating 25:1 spray unit.
2. Tips - Graco 163-721, 163-823 or equivalent, for parts larger than 12" x 12".
Graco 163-415 or equivalent for extrusions and very small parts.
3. Tip filter unit - consists of 1 only Graco 205-264 tip filter 100 mesh, 1 only Graco 164-120 Retainer, and 1 only Graco 164-121 Retainer Nut.

Pressures and Temperatures:

1. Air pressure - 60 - 70#
2. Back pressure (Hot Airless) - 1,600 - 1,800# fluid pressure.
3. Temperature - Ambient to 200°F.

Application: Hold the spray gun 10 to 14 inches from the part. The speed with which the spray gun is moved determines the quality of the sprayed film. The more rapidly the spray gun is moved over the part, the better the quality of the film.

COLD AIRLESS SPRAY

1. Apply one fast box coat. Dry tack free.
 2. Apply two fast box coats. Allow to dry 15 minutes.
 3. Apply two or three box coats. Allow to dry.
 4. Resultant dry film build should be 8 to 10 mils.
- Note: Optimum viscosity for cold airless spray application is 15 - 16 seconds #5 Zahn cup.

HOT AIRLESS SPRAY

1. Apply two fast box coats. Dry tack free.
2. Apply two fast box coats. Allow to dry for 15 minutes or more.
3. Apply 2 or 3 box coats. Allow to dry. Resultant film build should be 9 to 11 mils.

Should heavier films be required, apply additional coats. A box coat consists of a series of vertical and horizontal passes over the same surface. A 50 - 75% overlap is used depending on the speed with which the spray gun is moved.

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